WADCO NEWS

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MACHINE MADE CHAIN

Simple but Wonderfull

Machines take the place of hands and head

For the cynical pleasure of the experienced chain man and the indulgence of those who peruse this feeble attempt on machine made chain, this article is written, hoping that those who may be interested in knowing a little something of allied jewelry lines may benefit, and perhaps, increase their understanding a little.

The fact that this item of jewelry is machine made in no way should delude you into the belief that it is an easy matter to produce this article, and, while it is much easier and more uniform results are obtained in this manner, still, one little operation going wrong in many may cause the entire lot to be scrapped as useless, thus losing the firm the entire labor expended as well as the biggest part of the purchase price of the material; in fact, all that may be realized is the scrap value of the metals involved.

The preliminary introduction over, the first step in the actual process of producing chain brings to light the solder-filled wire, wound on reels and ready to be set on the machines for action in process to be made into chain. We explained the method and manner of producing solder-filled wire in a previous article. This wire is placed on a spindle rest, so that it will revolve freely and the end inserted into the machine through a guide until the feed rolls grip it and carry it into the machine to be fed into the dies that made the links. The diameter of the ring to be made is known and the feed rolls bring the wire forward with each revolution of the dies, a certain length, or to be more explicit, just long enough for the dies to bend the wire into a perfect ring so that both of the ends will fit snugly together. Micrometer measurements must be taken of the wire to ascertain its thickness and assure the operator that it is right for the dies in the machine. This slight detail examined and satisfactorily disposed of, the machine is set in motion and after the first yard is produced measurements must be taken of the ring diameter to see that it is up to the measurements required. If, for instance, you have used .020 solder-filled wire and the ring diameter is set at .070 to produce the standard the trade call for, and you find on investigation of the first yard of chain made, the ring diameter is not the required size, your machine needs adjustment somewhere and should you attempt to solder this piece of chain you would find almost invariably that it would either solder very poorly or not at all. This is only one instance where an operator has his troubles and should he be careless he could easily cost the firm a good deal of money. A number of other sources of trouble might arise that would be accountable for the chain failing to solder and it is quite possible that an operator could not ascertain the trouble. The cutter that cuts the wire to the ring length may have become dull and in cutting through the wire, blunt the ends covering the solder-filling by drawing the surface of the wire down over it. The ring dies may not have been set accurately and while the rings may look all right to the naked eye, micrometer measurements appear as required, still one end of the ring might easily fail to fit against the other so that the solder would run out and solder the link. The wire that is used in the process of making chain must be of a certain hardness and should the manufacturer of this product fail to give you the right kind of service you might possibly receive wire hardened to such a degree that when soldered it would spring apart when the heat expanded it. The grooved dies that form the ring may easily become worn through the use of hard wire or constant use and this in turn would tend to leave

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Waste Not - Want Not

Hard Work Requires Adapted Leisure.

The greatest obstacle in the path to advancement and success of the average worker today is waste; and the most valuable quantity wasted is time.

Everybody is aware that for the wage earner the element of time is divided into three divisions—work, recreation, rest. But only a few are alive to the realization that from each of these divisions flows a little stream made up of wasted moments. And these little streams, flowing on through life, merge into one swiftly moving current of lost golden hours —hours that can never be reclaimed.

The place to dam this river of Wasted Hours is at the source. You cannot hope to check its onward rush at the middle, much less at its end, where it broadens out into a whirlpool that gently sucks you into a vortex of mediocrity.

If you are a waster, you must cut out the waste. When at work give of the best that is in you. Continually strive, setting up goal after goal. The ladder is high and the rungs are many—and slippery. If you are giving only six hours of effort—and that half-hearted—out of the eight you are being paid for, you are wasting two hours of constructive endeavor every working day. How can you hope for advancement?

When at leisure make the most of it. If your work keeps you away from the sunshine and the fresh air the greater part of the day, all the more reason why your spare time should be spent out in the open as much as possible. And if out of your leisure you cannot find time for at least one hour of upbuilding study a day, thus fitting yourself for a more responsible position, how can you hope to succeed?

The harder a man works, the more he should value his hours of rest. Hours that are spent in dissipation, instead of laying up a store of energy for the morrow's tasks, are

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EDITORIALS

"YOUR EDITOR"

Once upon a time
Somebody thought it
Would be a
Fine idea to have an
Employees' House Organ, a
Semi-Monthly Publication — that would be
Clever and newsy.
That would be
Read by all and that
Everybody would
Contribute to and that—well
Anyway, we got the job as
EDITOR.

And since then
Experience has taught us what
It means to have people
Make promises and never keep them,
To rack our brains
And paw the air for
IDEAS.
And to have old friends shun us
Like the plague either because
They feared they'd be asked to write
A story or because they'd
Had their feelings hurt or something
When they did or didn't get
Written up!

And we learned
To fight twice every month with
The Printer
And swear at the
Engravers, to plead and beg and
Threaten in order to get
Out on time and
Then be asked 'bout a million
Times a day, "When will the
WADCO be out?" by someone
Who never contributed one single
THING
For the WADCO—all of
Which has made us grow
Old prematurely and be
SADDER
If wiser about human nature
However, this fills the space easily
AND
I thank you.

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wasted hours. They are hours that leave the workman heavy-eyed, dull, lethargic. How can such a one hope to get on?

Harbor your resources. Be like the athlete who wins a long-distance race.—Coal Age.

Minutes Lost Per Employee

	Jan. 29	Feb. 5	Feb. 12
Mesh Room,	5	4	4
Assembly,	14	13	11
Dept. A,	0	10	0
Lining Dept.,	0	0	4
Polishing,	9	9	9
Coloring,	4	6	7
Soldered Mesh,	7	11	6
Bench,	15	9	10
Stamp & Press,	19	18	16
Unsoldered Mesh,	14	9	9
Tool Room,	17	13	11
Maintenance,	38	23	32
Repair,	12	9	10
Rolling,	8	0	0
Shipping,	2	0	0
Office,	12	12	4
Dept B.	14	20	7
Die Dept.,	16	3	0
Whiting Chain,	4	5	6
Total hrs. lost,	130	111	104

When we went to school we did not jump over desks nor children to see who could reach the door first. We stood and let one aisle go out. Now, I think we could do something of that sort here. We are only children grown up (at least we are supposed to be). Why not stand up and go in turn to ring out? It would not take any longer than it does to jump and walk over the others to get to the clock first. The car won't go until the crowd gets there.

MIDDLEBORO NEWS

I never dreamed I'd go to Ireland
But to Ireland I have flown,
And tried to get a story
Which to him alone is known.

But he refused to tell it,
And I broadly smiled, at that,
For when Ireland has a story
He "keeps it 'neath his hat."

Now I am not discouraged,
It but means a short delay
For I'm sure I'll get that story
In some diplomatic way.

Arthur still is worried
But the cause is not a girl;
It's something far more serious
That sets his thoughts awhirl.

That famous trust of Simon Swig
Has failed, and all fell through,
So Arthur now is anxious,
And don't know what to do.

Because his stack of pennies
In the Savings Bank is stored,
And that may fail tomorrow
Then he will lose his "hoard."

Now, we should be sympathetic
And all our smiles restrain,
For he figures he has all to lose
And nothing much to gain.

Irene is demonstrating
A way to save our dimes,
She chews a single piece of gum
For days and weeks at times.

The brand is poor indeed
That will not stand the test,
But Irene knows them all
And can tell which one is best.

Our friends in Plainville tell us
(Through the medium of the "News")
Of the Parties they are having
And the good times that we lose.

Now, we're not consumed with envy,
But we'll tell you just the same,
If we should get an invite
We think you'd find us "game".

If that invitation should arrive,
A week or two in advance,
We think we all could manage
To join you all at the dance.

—Hattie E. Goodwin.

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a link opened far enough so that the solder would not form both ends together. Most of these troubles are so difficult to discern that it is not discovered until the chain reaches the soldering machine and the solderer rubs it into the operator for trying to ruin his reputation when he fails to get the results he expected in soldering.

The action of the machine is simple and for the benefit of those not having had the opportunity to view it in motion we will try to draw a word picture as we see it from the observer's optics. The wire works through a guide to the feed rolls that feed the wire, a specified length with each operation or revolution of the machine, over the forming dies. The cutter cuts the wire at this point and the lower die receives the wire through the action of a plunger that bends it down into it. This die is grooved to the exact size of the wire and the lower half of the ring is made in this die. The ring up to this point would remind you of the letter U. As the plunger recedes the upper die immediately comes into action closing the U-shaped ring into a perfect O, making the ring with both solder filled ends in contact with each other, thus when heat is applied the solder runs and solders the ring. The die then takes a half turn, reversing the position of the ring and the wire for the next ring is fed through the previous ring, the operation repeated and so on until you have the cable chain made up.

We have reviewed a few of the troubles that might and do occur frequently to ruin the chain man's disposition and we will go still further on that line and point out the fact that the chain, although it is made into the cable formation is not by any means finished nor ready to wear. As the produce comes from the machine it is fed into a pan or revolving receptacle for the purpose of receiving it and laying it neatly and in condition to be handled without snarling it. The rings, it must be remembered, are still unsoldered and it does not take much tension to pull these fine wire rings apart when they are not soldered together. For instance, if the chain should travel over a certain

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SPORTS

FRANK BROWN, *Editor*

There has been plenty of bowling among the different departments since our last issue, but the greatest match of them all was the one bowled on Friday, March 4th. It was a match between the Planning and the Polishing Departments for a purse of $25.00. Both teams were keyed up for the fray, some with ginger-ale and some with moonshine for a bracer. The excitement at times was at fever-heat as they had rolled even strings, one each. Then the rubebr was started and the strong arm and keen eye of the Rabbit carried the College boys over the top a winner. The comments of some of the spectators were that Jesse was away off form and was suffering from stage fright in the two last boxes, while Barrows could not locate the willows at all in the first two boxes. For the winners, Rabbit rolled 106, 95, 100 in his try and was the high man. The Manchester Twins showed the effects of nerve control to good advantage. The polishers now feel that the steak supper will be forthcoming that they won in a previous game from them, but of course, it is up to Bud Kenyon to come across as it is said he is the keeper of the mazuma. Boys, be good sports and come across with the eats.

PLANNING DEPARTMENT

Crotty,	102	82	93	277
Rabbit,	1706	95	100	301
Kenyon,	86	89	88	263
G. Manchester,	93	82	100	275
E. Manchester,	87	85	89	261
				1377

POLISHING DEPARTMENT

Whiting,	109	92	82	273
Jillson,	90	83	83	256
Poor,	90	92	91	273
Barrows,	73	86	91	260
Fawcette,	85	106	94	285
				1347

As we have now four teams of Lady Bowlers, it is quite impossible to secure the Anawan alleys without a reservation two weeks in advance for them, but when they get there they make things hum and knock the pins all over the alleys. The Soldered Mesh team No. 1, which has been winning right along, received a jolt from the Assembling Room at their last contest that made them look like a lot of pikers. Elsie was there with a three-string total of 242, ant showed her ability to good advantage. Soldered Mesh team No. 2 trimmed the Gold Department on the same night with Flora Whiting leading all comers with a three-string total of 206. Watch this girl in future contests. She is a comer, all right. Louise led the Gold Department with 197.

The Stampers (or the Jammers Out) are still knocking the tar out of the Tool Department. They always thought because they were the trimmers of the work of the Stampers that they could also trim them in bowling, but they have had three trials at them and have been beaten every time so far. We would suggest that they challenge one of the girls' teams and then maybe they could win one by a small margin, eh Cap?

Even the fever has developed in the Whiting Chain Shop and the girls there felt they could roll them down the alley just as good as anyone else so they gave the Gold Mesh a chance to show waht they could do and the Mesh Girls put them to sleep in a nice quiet way with the following score. Passmore and St. John were high for the Mesh, rolling over 200 each which was a very good score. For the Chain girls Mabel Joyce was high with a three-string total of 178.

The Bench hands have now fully developed a team and will show what they can do during the incoming week. Look out for this bunch as we have some imported talent among us which will show to a wonderful advantage. Among the leaders is Ed. Martin whose record is among the high numbers. They are now in secret practice and will challenge all comers for fun or for marbles. So speak up you who think you have a chance.

CAUGHT IN THE MESH

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distance from machine to receptacle, the strain of the entire chain will rest on the first few newly make links at the source or just below the die, and while it would be impossible for the naked eye to see the link open up any still it has been known to do so. This defect, together with poor handling of the unsoldered chain in preparing it for soldering, may open up the links to such an extent that it will be impossible to solder with success.

After the chain is made on the machine the very delicate process of soldering follows, and while the solderer can usually pass the buck to the operator, yet there are some few things that influence chain in his department that the operator cannot be to blame for in any way. The process of handling applies here as well as at the machines and too often chain has been ruined by improper handling in this operation. The chain is boraxed and prepared so that the solder will run as easily as possible and run through a soldering machine that feeds the product through graduated heat until it solders. This machine must revolve and feed the chain at a specific rate of speed and the blaze giving the heat must be constant at a certain known degree. If either of these factors are not right you might either burn the chain or not solder it sufficiently. It is known to all chain men that heat expands the metal it is applied to and right here we call attention to the fact that similarly to the process of handling the chain as it is received in its receptacle from the chain machine, we have the same condition arising at the soldering machine only in a more pronounced way, in that the expansion of the ring through heat and the tension of the hanging chain serve to spring the links and they fail to solder or solder imperfectly and the chain requires, in consequence, much mending.

Soldering is not simply a process of starting up a soldering machine and presto, the finished chain soldered perfectly. No such thing, although manufacturers like to dream of the the Aladdin's lamp of perfection in this line. It is possible, but not very probable. For instance, we know the fusibility of the solder involved in the soldering and we gauge carefully the heat and get the chain soldering very satisfactorily and then some boob, unbeknown to you, opens the window on a very cold day and in a very short while the atmosphere has changed so that the soldering heat which you had gauged so perfectly and the chain which you were so satisfied with, began to come, for no reason whatever, rotten. After manoeuvering and changing the degre of heat you finally commence to get results more uniform and the boob closes the window, the atmosphere changes again and shortly you are burning the chain and cursing the soldering machine for a junk heap, in fact, you talk to it just as if it were human. There is no question but what the atmosphere has a great deal to do with heat constancy and with heat constancy and accurate revolutions from the soldering machine you are apt to get into very serious difficulties at times.

After the soldering process the chain is reeled and sent to the bench where it is cut into lengths, spring rings and swivels soldered to the ends. The coloring department cleans them up and puts a little coating of fine gold on them to improve the finish and the polishers polish and shine them to the lustre that makes them attractive on the market.

There is no question in the writer's mind, but that the firm making perfect chain and selling it on the market is also making it cheaper than the firm who puts out an inferior and unsatisfactory chain and if you will review the trouble that might occur as outlined in the article you will see that a firm producing good goods must have good help, men who know their business and stick to it. If you, yourself, have not been digging into your job and finding out what causes the trouble that is bothering you the most, then you have not been preparing yourself for more money and helping the firm to gain more business that your employment might remain constant with a steady revenue for you and yours that always tends to promote god feeling, happiness and content. If you have neglected this in your work, start today, clean up your job, get rid of the cobwebs and see how much you can improve your earning capacity from month to month. If you have the ability, the money is always waiting and is always diverted to the channels of ability and aggressiveness.

Answer to "Why is This?"

The unsoldered mesh girls might have a time clock of their own and that would avoid the aged and infirm from being knocked down and injured.

I wish to thank my many friends of the packing room and office for their kind wishes and generous contribution at the time of my recent bereavement.—Mrs. Grace Rhodes.

Sam Kenyon, Thomas Brierly and Richard Berkley attended a soccer game, Saturday, at Quincy, between the Fore River team and the Robin Dry Dock team of Brooklyn.

Bill Barton of the Planning Department was elected selectman and Willis Fuller was elected member of the school committee at Town Meeting last Monday.

The Die Cutting Department have moved into their new quarters. They were allotted 200 square feet in the new addition. Here they are able to get away from the noise and vibration of the stamp and tool rooms. They have the best location in the factory

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Come and Have Another Good Time

Negotiations are under way for a basketball game between our team and the R. J. Simmons Co. of Attleboro. The date has not yet been set, but it is quite probable that the game will be played March 21st. Frank Brown has accepted Gene Manchester's challenge and each will captain a team in the newest and funniest of all games, indoor kiddy-kar polo. Brown wishes it announced that he will personally appear, and this should be the biggest drawing card ever. Yours for the best time in your life.